

Date: Tuesday, 2/26/2008 8:02:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BELL CRANK
 Job Number : 37629
 Estimate Number : 11967
 P.O. Number :
 This Issue : 2/26/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2056
 First Issue : 1 / 1 Type : MACHINED PARTS Drawing Number : D2056 REV B2
 Previous Run : 31220 Drawing Revision : B2
 Written By :
 Checked & Approved By : 08 02 26 Material :
 Comment : Est. E 02.04.04 Added Rev.B2 NG Due Date : 3/14/2008 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1250X01250 6061-T6 Bar 1.25 x 1.25"



Comment: Qty.: 0.2494 f(s)/Unit Total : 0.9975 f(s)

6061-T6 Bar 1.25 x 1.25"

Material: 6061-T6, 1.250" x 1.250"

Batch: M103220

08/03/07

(8)

2.0 BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 2.80" long

08/03/07

(8)

3.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2056

Tumble

Deburr any rough edges after tumbling

H.A./M.L./J.L 08/03/07

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A./M.L./J.L 08/03/07

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SF 08/03/08 (8)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

08-03-10

(8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELL CRANK

Job Number: 37629

Part Number: D2056

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M/00700



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FL 08/03/11 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/23/11 (8X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 10

AS 08/03/12 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Doc 03/12 (8)

Job Completion



mi 2008/3/12

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

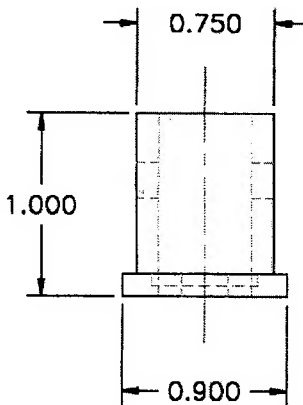
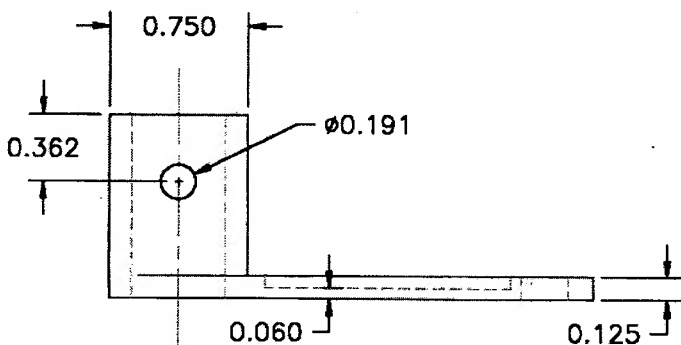
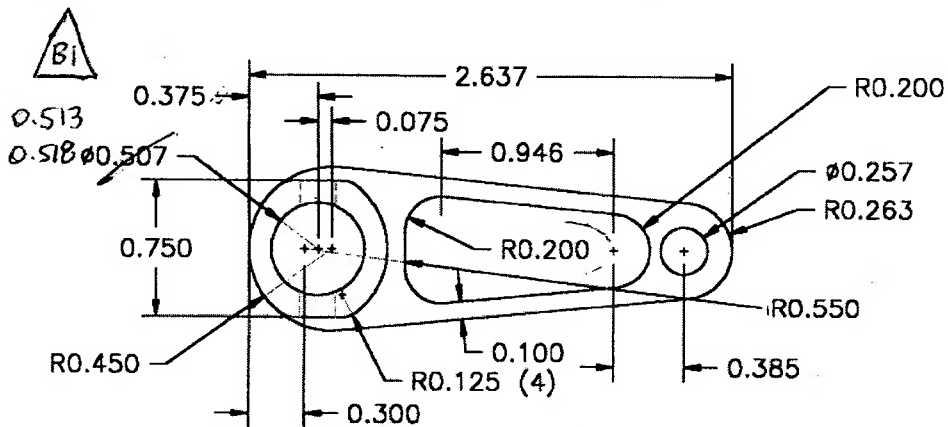
NOTE: Date & initial all entries

DART



RELEASED
990428 AE

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
B WILLIAMS	K HAND		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		D2056	
92.03.13		TITLE	SCALE
		BELL CRANK	1:1
B	95.11.02	RE-DESIGN	
B1	01.06.04	MODIFY HOLE SIZE, ADD PIC OPTION	
B2	02.12.20	ADD NOTE ON TOLERANCES	



△B1 ACID ETCH & ANODIZE PER
DART QSE .005 4.1
POWDER COAT BLACK SANDEN
(4.3.5.7) PER DART
QSE .005 4.3

△B2

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
FOR ORDER
NO 37624

DART AEROSPACE LTD		Work Order: 37629
Description: BELL CRANK		Part Number: D2056
Inspection Dwg: D2056 Rev: B2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/- .010	0.750	✓			
0.900	+/- .010	0.900	✓			
1.000	+/- .010	1.000	✓			
0.125	+/- .010	0.120	✓			
0.060	+/- .010	0.061	✓			
Ø0.191	+0.005/-0.001	Ø0.191	✓			
0.362	+/- .010	0.367	✓			
0.750	+/- .010	0.7515	✓			
0.385	+/- .010	0.386	✓			
Ø0.257	+0.006/-0.001	Ø0.260	✓			
0.100	+/- .010	0.097	✓			
0.300	+/- .010	0.300	✓			
0.946	+/- .010	0.943	✓			
0.750	+/- .010	0.750	✓			
0.075	+/- .010	0.075	✓			
2.637	+/- .010	2.638	✓			
0.375	+/- .010	0.376	✓			
Ø0.513/0.518	0.513 / 0.518	Ø0.516	✓			
R0.450	+/- .010	R0.450	✓			
R0.125	+/- .010	R0.125	✓			
R0.260	+/- .010	R0.260	✓			
R0.550	+/- .010	R0.550	✓			
R0.263	+/- .010	R0.263	✓			

Measured by: H.A./m	Audited by: [Signature]	Prototype Approval:
Date: 08/03/07	Date: 08.03.07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	